

Work Order ID 81374

Wednesday, March 14, 2012 10:28:58 AM

81374

April 2nd

Page 1

Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Base Assembly, 350
 Start Date: 3/14/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/30/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ME Date: 12-03-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	A								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 118366 0.00
 Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

Pl 12-03-23 1x Ø

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

BE 12-03-23 1 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							

8 12/03/26

1XPM-12/03/27

Dart Aerospace Ltd

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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00				1	2	(DP)	12/03/29
Powder Coating	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT:								
	START TIME: 3h45								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 4h15								
	*****2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
						1	12-3-27		

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150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing	Pick Kit								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: DH030-041	0.00							
170									
Packaging	Memo	0.00							
Packaging									

81373

1 BL 12-3-08

8.2/03/20

1 BL 12-3-08

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180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/3/29 

062 03-28

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Picklist Print

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
verified by:EC

IPP Rev:B chg qty's DD 10.04.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581 Mounting Bracket		Manufactured	No			100	Each	29.0000	2	2		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		29							
				69739		1							
				70766		2							
				77045		1							
				77523		25							
✓ D3913-1 Rib		Manufactured	No			100	Each	1.0000	1	1		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		1							
				78039		1							
✓ D3913-15 Wide Handle Plate		Manufactured	No			100	Each	1.0000	1	1		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		1							
				78321		1							
✓ D3913-3 Rib		Manufactured	No			100	Each	5.0000	1	1		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		5							
				69160		1							
				78287		4							
✓ D3913-7 Rib		Manufactured	No			100	Each	6.0000	2	2		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		6							
				79416		6							

3

380790 → ①

380778 → ①

①

379416 → ②

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-9 Manufactured No 100 Each 2.0000
Hinge Rib

Location	Loc Qty	Loc Code
WA006	2	
70138	1	
79876	1	

1 1 *plc 12.03.22*

✓ D3916-041 Manufactured No 100 Each 2.0000
Rib Assembly

Location	Loc Qty	Loc Code
WA006	2	
69161	2	

2 2 *plc 12.03.22*
B81441 → ①

✓ D3916-5 Manufactured No 100 Each 8.0000
Light Rib

Location	Loc Qty	Loc Code
WA006	8	
79908	8	

3 3 *plc 12.03.22*

✓ D4016-1 Manufactured No 100 Each 23.0000
Hinge Half, Base

Location	Loc Qty	Loc Code
WA005	23	
75281	4	
79413	19	

3 3 *plc 12.03.22*
B79908 → ③

✓ D4017-7 Manufactured No 100 Each 2.0000
Rib

Location	Loc Qty	Loc Code
WA005	2	
69730	1	
74682	1	

1 1 *plc 12.03.22*
B81176 → ①

W/O:		WORK ORDER CHANGES					
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Parent Item: D3913-041

Start Date: 3/14/2012

Required Date: 3/30/2012

Parent Item Name: Long Basket Base Assembly, 350

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-9 Rib Manufactured No

100 Each 8.0000

2

2

Location

Loc Qty

Loc Code

WA
79415
WA006
70341
73531

2
2
6
2
4

381515 → ⑤

✓ D4020-11 End Mesh, Basket Manufactured No

100 Each 10.0000

2

2

Location

Loc Qty

Loc Code

WA035
69648
78693

10
2
8

② 3 ③ lpl 12.03.22

✓ D4021-1 Handle Plate Manufactured No

100 Each 8.0000

3

3

Location

Loc Qty

Loc Code

WA
69518
74316
74946
79414

8
0
0
0
8

③ 381172 → ① lpl 12.03.22

✓ D4034-041 Aft Upper Rib Assembly Manufactured No

100 Each 0.0000

1

1

✓ D4034-043 Fwd Upper Rib Assembly Manufactured No

100 Each 3.0000

1

1

Location

Loc Qty

Loc Code

WA006
78036
78329

3
1
2

①

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Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

✓ M304EX0.75-16F
Expanded Metal Flat SS

Purchased

No

100 sf

772.5296

33

33

6/12-03-22

Location

Loc Qty

Loc Code

WA	0.0001156
119180	0.0001156
WA035	772.5294457
117197	102.9026
117896	29.49258
118153	76.8473
118955	82.17
119180	53.6958107
119729	28.1132686
120153	2.97557478
120318	85.2413116
120917	311.09

33

AN3-10A
Bolt

Purchased

No

150 Each

379.0000

6

6

Location

Loc Qty

Loc Code

GA	75
119084	75
ST351	304
117795	4
120873	300

119084

AN960JD8

Washer

D2931

Bumper

NAS1149DN832J

Purchased

No

150 Each

0.0000

2

2

119717

Manufactured

No

150 Each

496.0000

2

2

Location

Loc Qty

Loc Code

ST504	496
46064	496

46064

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Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-5
Blanking Plate

Manufactured No

150 Each 7.0000

2

2

Location

Loc Qty

Loc Code

GA

7

73478

7

MS20600-AD4W3
Cherry Rivets

Purchased No

150 Each 1,304.0000

2

2

Location

Loc Qty

Loc Code

ST321

1171

111636

36

117505

6

117601

27

118626

602

120308

500

WA018

133

107939

133

MS21042L3
Nut

Purchased No

150 Each 3,192.0000

6

6

Location

Loc Qty

Loc Code

ST300

3192

117441

16

117885

32

118451

5

118927

3

119017

2956

119075

180

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Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

782.0000

12

12

WASHER

CE 12/3/28 ①

Location

Loc Qty

Loc Code

ST275

782

117735

37

119225

142

120498

200

120910

200

120986

200

17317

3

120498

Dart Aerospace Ltd

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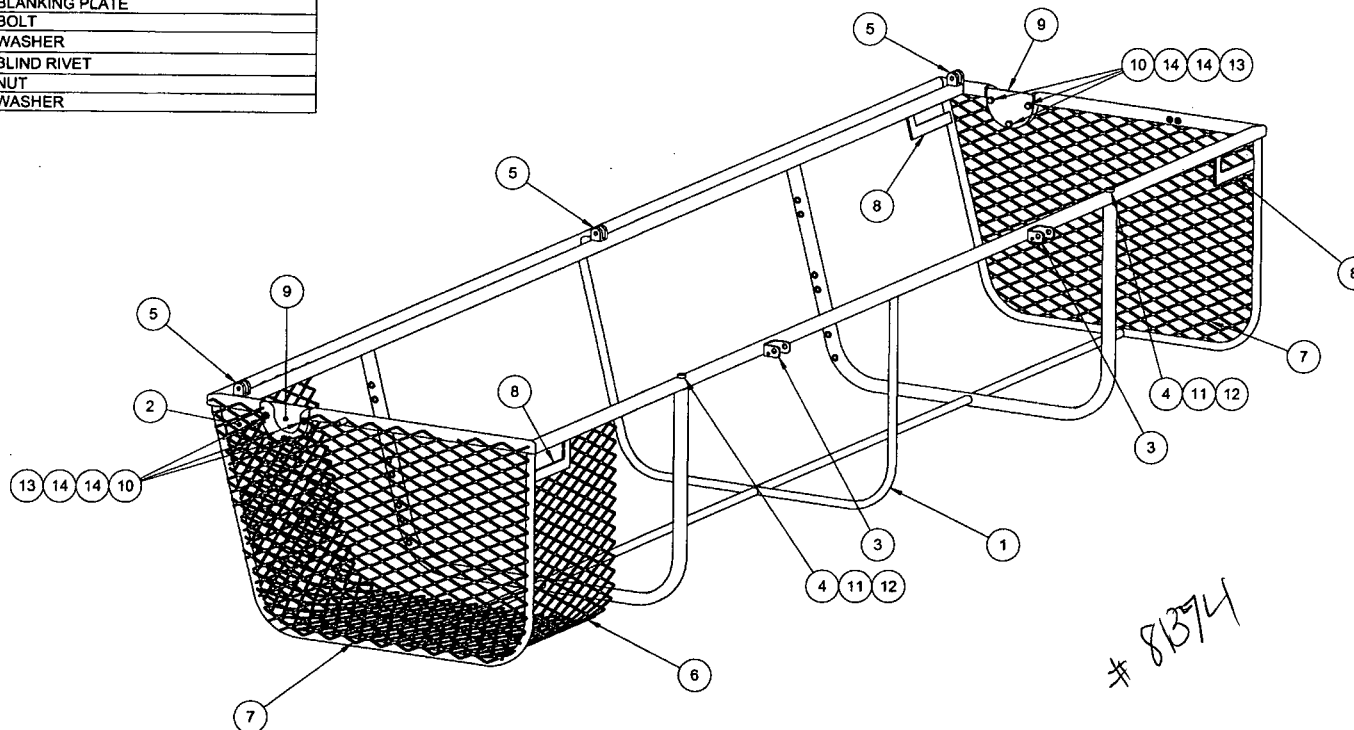
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN980JD8	WASHER
12	2	MS20800AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-03-22
WJP

81374

Dart Aerospace Ltd

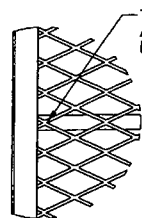
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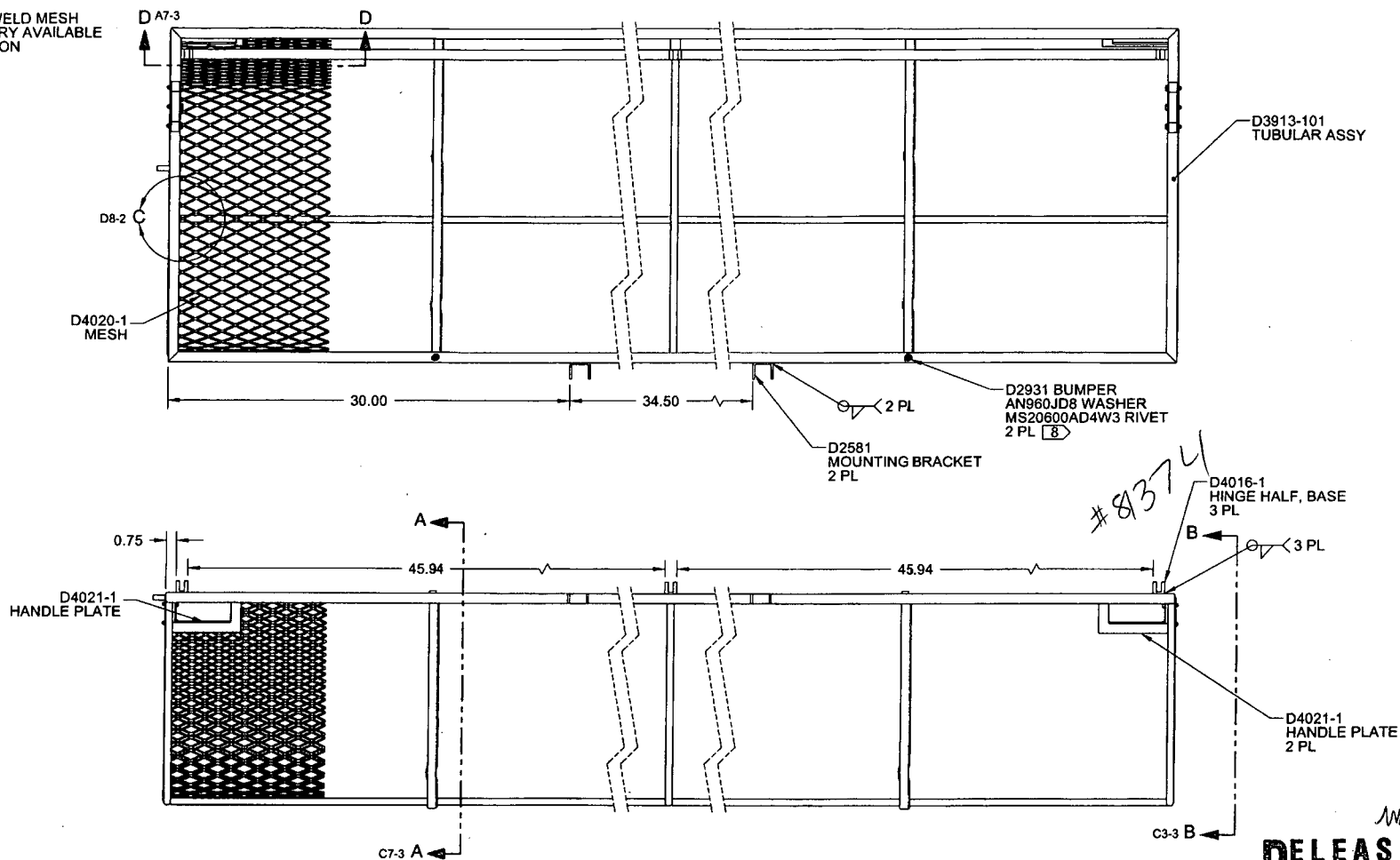
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DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

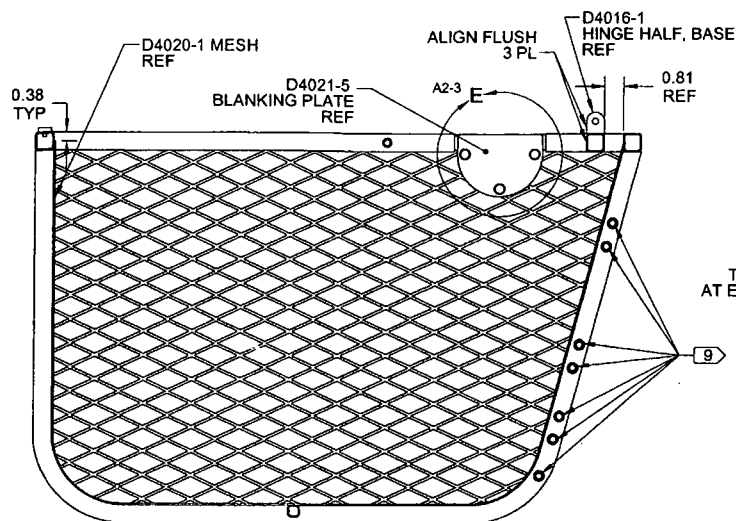
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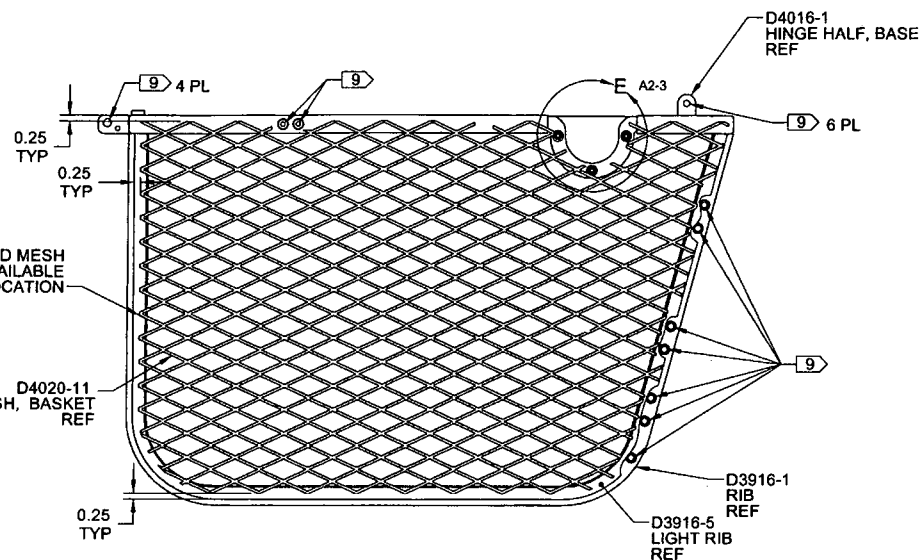
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

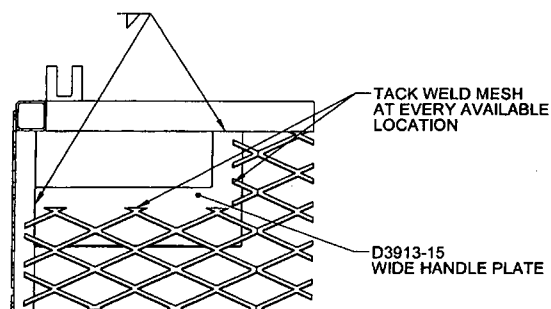
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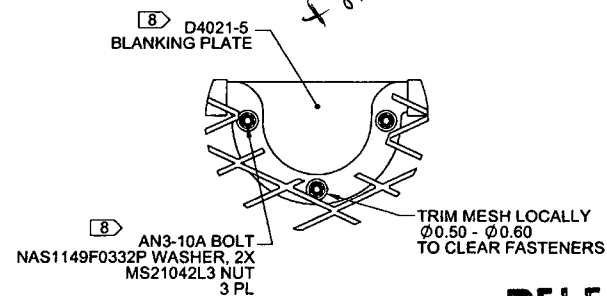
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. A
MFG. APPR.	h	D3913	SHEET 3 OF 6
APPROVED	h	TITLE	SCALE
DE APPR.	h	LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

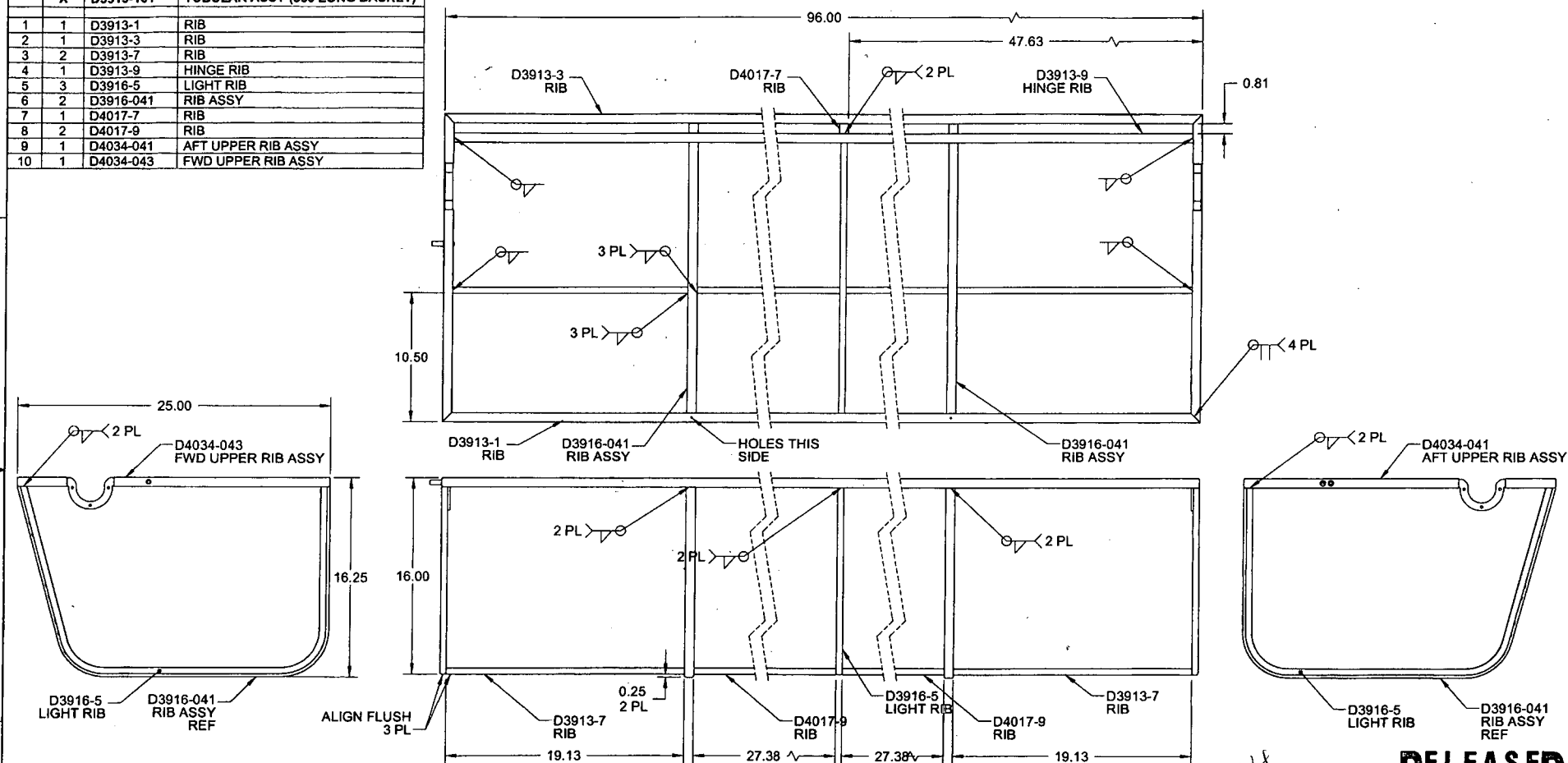
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
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MFG. APPR.		D3913	SHEET 4 OF 6
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DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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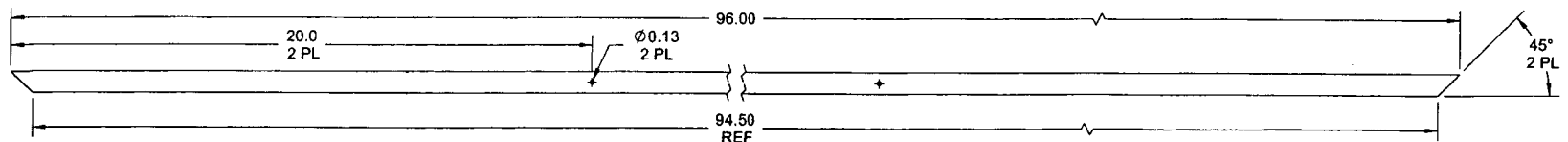
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

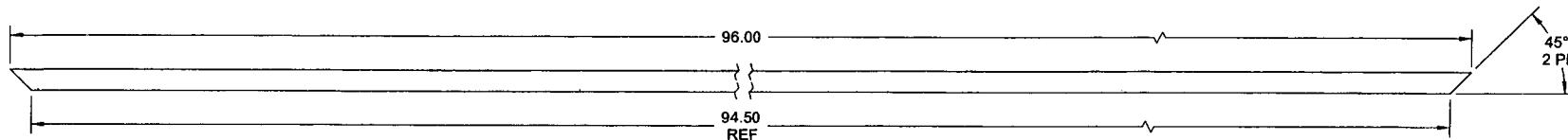
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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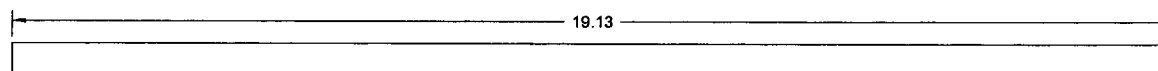
NOTE: Date & initial all entries



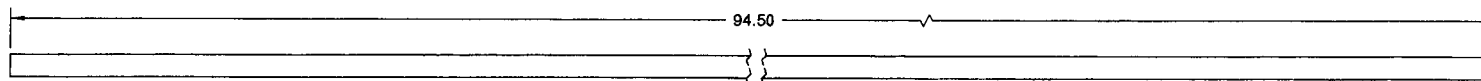
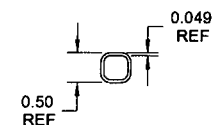
D3913-1 RIB



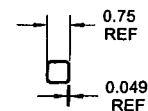
D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB



NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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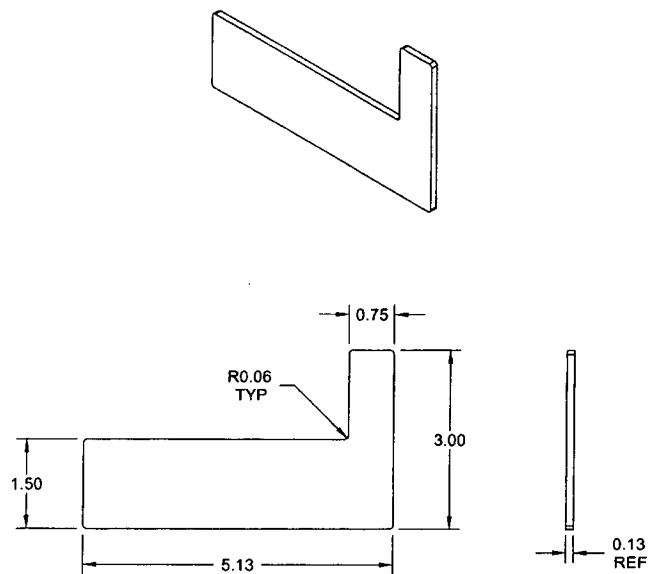
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries